Dart Aerospace Ltd. Monday, 2/19/2007 8:07:41 AM Date: Kim Johnston User: **Process Sheet** : BUSHING : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer Job Number : 30749 : 11041 **Estimate Number** : NIA : D2809 P.O. Number Part Number S.O. No. : NA D2809 REV A1 : 2/19/2007 **Drawing Number** This Issue · N/A Prsht Rev. Project Number : NA · MACHINED PARTS : A1 Type **Drawing Revision** First Issue : NIA : 28645 Material Previous Run : 2/26/2007 Qty: 50 Um: **Due Date** Written By Checked & Approved By : Est C Now turned in house Comment 02-03.07 **Additional Product** Job Number: Description: Seq. #: 6061-T6 Round Bar .500" 1.0 M6061T6R0500 Comment: Qtv.: 5.2238 f(s) 0.1045 f(s)/Unit Total: 6061-T6 Round Bar .500" 1 507/00/20 Batch: M102447 Material: 6061-T6 (QQ-A-250-11) rod .500"Ø 2.0 HARDINGE Comment: HARDINGE CNC LATHE SMALL Machine as per Folio FA204 INSPECT PARTS AS THEY COME OFF MACHINE QC2 3.0 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 4.0 QC8 SECOND CHECK

Comment: SECOND CHECK

SMALL & MEDIUM FAB RESOURCE 1

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOUR

Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & deburr all sharp edges as per dwg

8B 07/021

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## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	):	PAR #: Fault Category:	NCR: Yes	Nổ DQ	A.C	∑ Date: <u> </u>	71/02/28	

QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Varification	A	A		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspecto		
	-									
		•					,			

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 8:07:41 AM Kim Johnston User: **Process Sheet** Drawing Name: BUSHING Customer: CU-DAR001 Dart Helicopters Services Part Number: D2809 Job Number: 30749 Job Number: Description: Seq. #: Machine Or Operation: HAND FINISHING RESOURCE #1 HAND FINISHING1 6.0 07/02/26 × 68 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 POWDER COATING 7.0 m/0314/ Comment: POWDER COATING Powder coat WHITE per QSI 005 4.3 COAT/CHEMICAL CONVERSION 8.0 QC3 PACKAGING RESOURCE #1 9.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 10.0 QC21 Comment: FINAL I TION/W/O RELEASE 1 0/102,28 Job Completion

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
	:							
Part No		PAR #· Fault Category:	NCD, Voc	No DO		Data		

Part No:	PAR #:	Fault Category:	NCR:	Yes No	DQA:	Date: _	<del></del>
			•	A: N/C	Closed:	Date:	

	WORK ORDER NON-CONFORMANCE (NCR)									
	Description of NC		Corrective Action Section B		Verification	A 1	Approval QC Inspector			
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng				
						:				
				:						
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Section C	STEP Description of NC Section A Proval Initial Action Description Sign & Section C Se			

NOTE: Date & initial all entries

Description: Spacer

Description Dwg: D2809

Rev: A1

Work Order: 30749

Part Number: D2809

Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.191	+0.005/-0.000	.193				
Ø0.313	+0.005/-0.000	.314				
Ø0.500	+/-0.005	, 499	-			
0.359	+/-0.010	,359				-
1.194	+/-0.010	1.192	. /	,		
0.040 x 45°	+/-0.010	10/01/4CD				
R0.020	+/-0.010	1.192 ,000 L,00				
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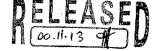
Measured by:	Audited by:	J.L	Prototype Approval:	N/A
Date: 67/62/27	Date:	07/02/22	Date:	N/A

Rev	Date	Change	Revised by	Appro	77
Α	05.04.26	New Issue	KJ/JLM A		
L				/_/	*

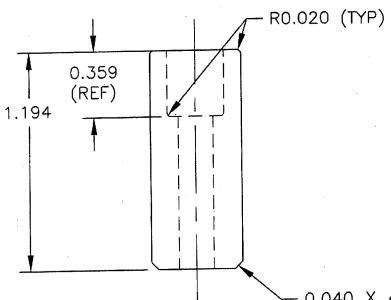




	DESIG	#	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
\	CHECK	(ED _	APPROVAD	DRAWING NO. REV. A
)	,	P		D2809 SHEET 1 OF 1
	DATE		<u> </u>	TITLE SCALE
	00.1	1.07		SPACER 2:1
	·A		,00.11.07	NEW ISSUE
	As	1.00	61.04.76	Ann POWDER COAT: do sono was do son



·	∕- ø0.313+8.885	C'BORE	0.359	DEEP
Ø0.191 +0.885			·	•
	10.507+0	1.001 Hack	±0.005	
		.000 WU.SU	, -0.402	



0.040 X 45° CHAMFER

SHOP COPY RETURN TO

ENGINEERING

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TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED WITHOUT NOTICE BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.000

MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER GOAT WHITE (4.3.5.1) OR GREY SAMOTEX (4.3.5.6) OR BLACK SAMOTEX (4.3.5.7) OR GREEN SAMOTEX (4.3.5.8)

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